

Work Order ID 56834 - 2



March 10, 2010 3:50:56 PM

ASAD




Page 1


Item ID: D3564-11 ~~ASAD~~ Accept  Setup Start 
Revision ID:
Item Name: Wearshoe SPLIT. Stop 
Start Date: 10/03/2010 Start Qty: 12.00  Cust Item ID:
Required Date: 17/03/2010 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: 14 Date: 10-3-11 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	Rev D								

100  0.00
Waterjet FLOW WATER JET
Memo 0.00
1-Cut as per Dwg D3564 ***** (D3564-1F) ***** ☐ Dwg Rev: D ☐ Prog
Rev: D ☐ 2-Deburr if necessary
304. 062 10-3-16 (13)

110  0.00
QC QC2- Inspect parts off machine FAI/FAIB
Memo 0.00
Quality Control 10-3-16

120  0.00
QC QC8- Inspect parts - second check
Memo 0.00
Quality Control 5/10/16 (+13)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56834

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Page 2

Item ID: D3564-11

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 10/03/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT8179

8/10/03/17

13

0

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/03/17

417

150



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
Weld hardcoat as per Dwg D3437

M113521

EL 10-3-22 x9

W/O:		WORK ORDER CHANGES						
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Work Order ID 56834

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Page 3

Item ID: D3564-11

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Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 10/03/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

5/10/03/23

(X9)

Memo

0.00

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/10/03/23

(X9)

Memo

0.00

180



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

11/12/588

Memo

0.00

=> 10/03/24

(X9)

START TIME: 7:15AM FINISH TIME: 7:45AM OVEN TEMPERATURE: 320°F

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Work Order ID 56834

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Item ID: D3564-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 10/03/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 17/03/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

BR 10-3-24 ⑨

200



Packaging

Packaging

Identify as per dwg & Stock Location:

FP-19

0.00

Memo

0.00

MS 10/03/2010

⑨

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24 JF
mf 10-3-24

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

Picklist Print

March 10, 2010 3:51:00 PM

Page 1

Work Order ID: 56834



Parent Item: D3564-11



Parent Item Name: Wearshoe

Start Date: 10/03/2010

Required Date: 17/03/2010

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ

Start Qty: 12.00

Required Qty: 12.00

M304S16GA

Purchased

No

100 sf

164.3899 17.8105



304/316 Sheet .063

10-3-16

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

164.3898737

106860

8.0295

111924

25.1689737

112442

29.8865

113295

101.3049

13

113245

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	56834
Description: Wearshoe		Part Number:	D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.224	X			
2.432	+/-0.010	2.431	X			
2.50	+/-0.030	2.501	X			
6.000	+/-0.010	6.000	X			
12.104	+/-0.010	12.104	X			
18.000	+/-0.010	18.000	X			
18.00	+/-0.030	18.00	X			
9.00	+/-0.030	9.00	X			
11.50	+/-0.030	11.50	X			
0.300 x 0.300	+/-0.010	300X300	X			
Ø0.188	+0.005/-0.001	.189	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.068	X			

Measured by: <u>RB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-3-16</u>	Date: <u>10/03/16</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
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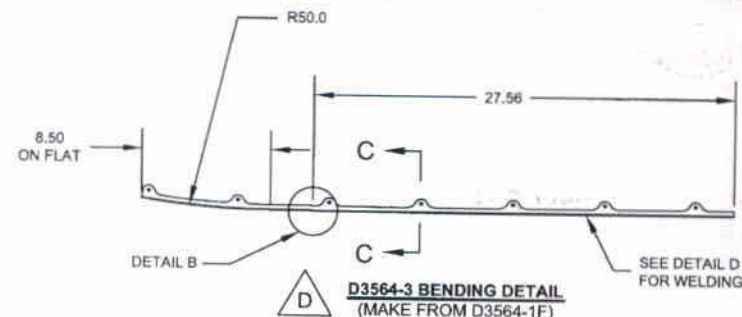
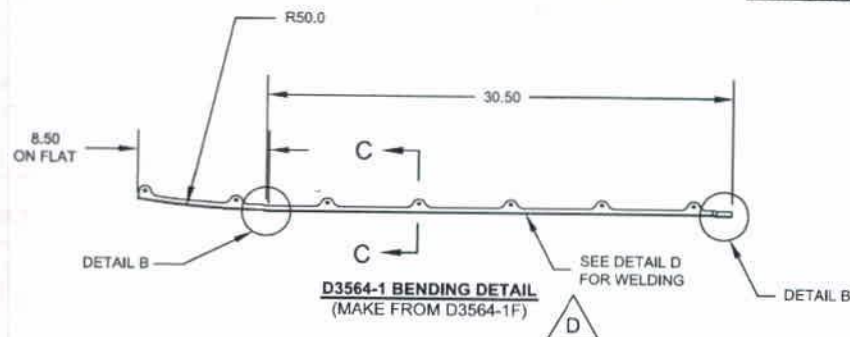
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54834
3810-3-11

RELEASED

07.09.04

D3564-1F FLAT PATTERN



D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT CL

WEIGHTS:

D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8; UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. 1
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

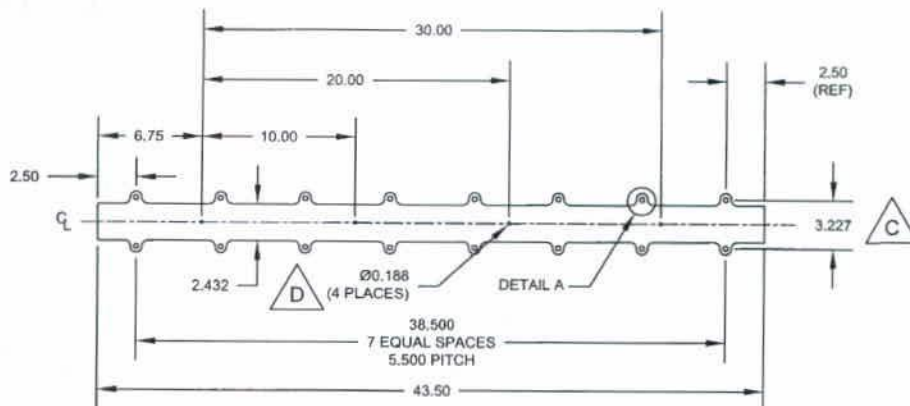
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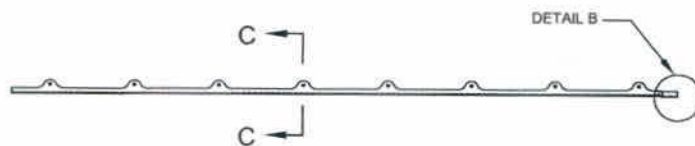
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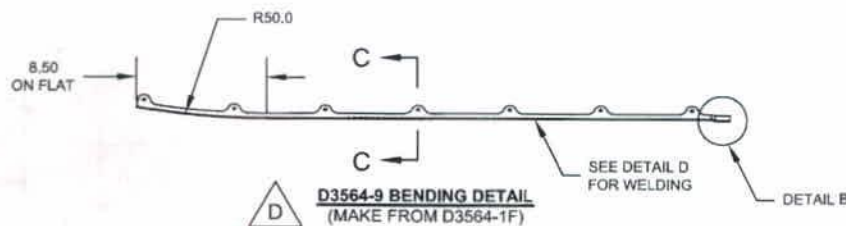
NOTE: Date & initial all entries



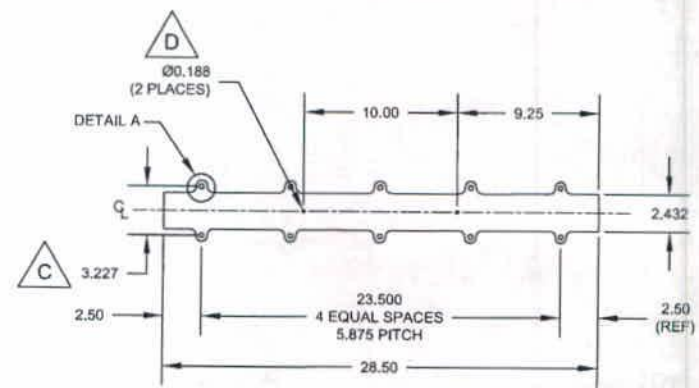
D3564-5F FLAT PATTERN



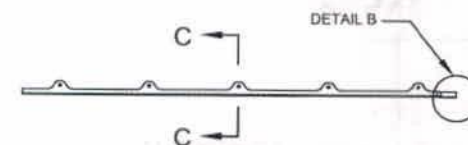
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



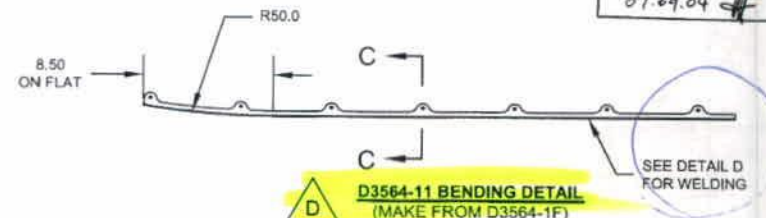
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

W/0 36834

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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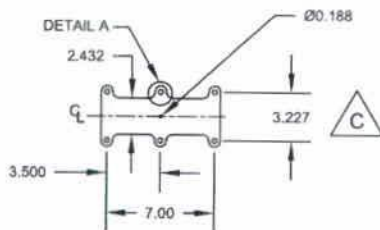
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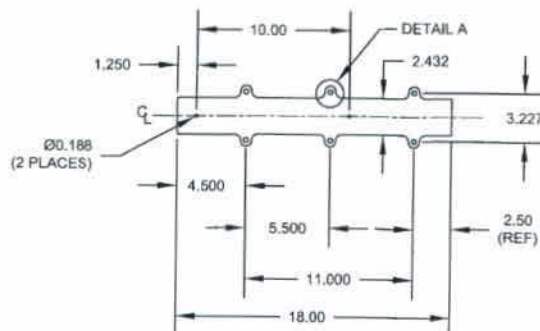
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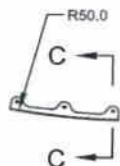
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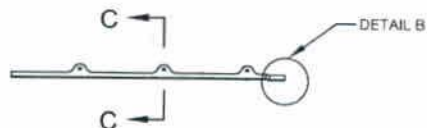
D3564-13F FLAT PATTERN



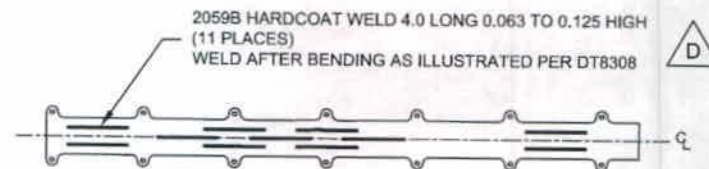
D3564-15F FLAT PATTERN



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



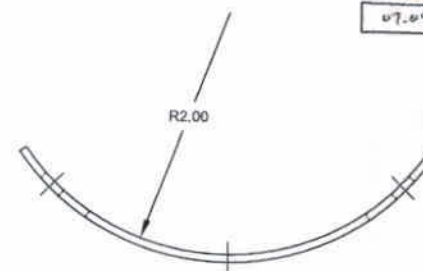
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



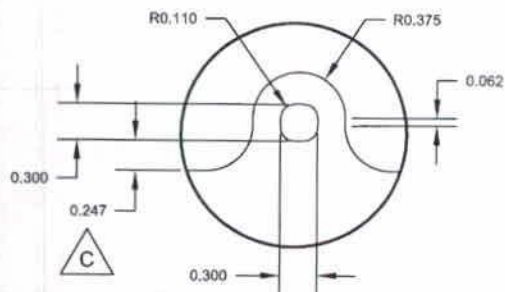
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)

RELEASED

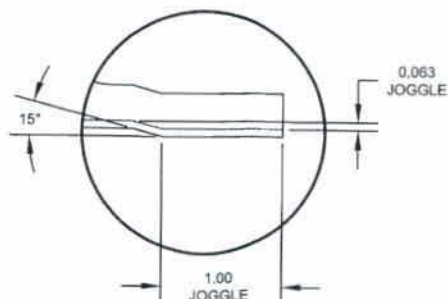
07.07.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH		
MFG. APPR.	PH	DRAWING NO. D3564	REV. D
APPROVED	PH	TITLE WEARSHOE	SHEET 3 OF 3
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